

# Work Order ID 58294-1

May 3, 2010 10:27:26 AM

*Split*



Page 1

Item ID: D2565-111

Accept



Setup Start



Revision ID:

Stop



Item Name: Strut

Start Date: 5/03/10

Start Qty: <sup>3</sup>10:00



Cust Item ID:

Required Date: 5/05/10

Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date: *10-5-03*

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D2565

Rev E

100

0.00



Brake NC

NC BRAKE

Memo

0.00

Brake NC

Punch as per Dwg D2565 using DT 8313

*See 10/05/12*

*(10)*

110

0.00



Small Fab

Small Fab

Memo

0.00

Small Fab

Deburr and polish

*=> m-l 10/05/17*

*(3x)*

120

0.00



QC

QC5- Inspect part completeness to step on W/O

Memo

0.00

Quality Control

*See 10/05/17*

*(+3)*





# Work Order ID 58294

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Page 2

Item ID: D2565-111

Revision ID:

Item Name: Strut

Start Date: 5/03/10

Start Qty: 10.00

Required Date: 5/05/10

Req'd Qty: 10.00

Reference:

Approvals:

Process Plan:

QC:

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run Start

Stop

Sequence ID/  
Work Center ID

130



Powdercoat

Powder Coating

Operation  
Description

White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel

Memo

START TIME:

1:15pm

FINISH TIME:

12:45pm

OVEN TEMPERATURE:

400°F

Set Up/  
Run Hours

0.00

0.00

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

0.00

0.00

0.00

0.00

QC3- Inspect Part Finish

Memo

Identify as per dwg & Stock Location: 270

Memo

140



QC

Quality Control

150



Packaging

Packaging



Accept



Cust Item ID:

Customer:

Setup Start

Stop

Run Start

Stop

3 0

3 10-5-17.

10/5/17 (3)





# Work Order ID 58294

May 3, 2010 10:27:26 AM

Item ID: D2565-111

Revision ID:

Item Name: Strut

Start Date: 5/03/10

Start Qty: 10.00

Required Date: 5/05/10

Req'd Qty: 10.00

Reference:

Approvals:

Process Plan:

QC:

Sequence ID/  
Work Center ID

160



QC

Quality Control

Operation  
Description

QC21- Final Inspection - Work Order Release

Memo

Date:

Date:

Tooling:

SPC (Y/N):

Set Up/  
Run Hours

0.00

0.00

Accept



Setup Start



Stop



Cust Item ID:

Customer:

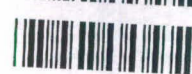
Date:

Date:

Run Start



Stop



Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

10/05/17  
10-5-17  
(3)





# Print

May 3, 2010 10:27:25 AM

Page 1

Work Order ID: 58294

Parent Item: D2565-111

Parent Item Name: Strut

Comments: IPP: E 01.06.04 Added Powder Coat, Removed Polish, and Added Inspection  
Levels 3 & 21 EC  
IPP: E 06.05.03 Change level 2/8 to QC5 EC

Start Date: 5/03/10

Required Date: 5/05/10

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/

Replacement Mfg/

Purchased

Bin  
No

Primary

Last

Route  
100

Unit of  
f

Qty on  
303.4562

Qty per Kit  
1.1375

Qty

Date

Status

M304TR0.750W.049

304 RD Tube .750 x .049W

Location

Loc Qty

Loc Code

MAT

275.5927

108498

0

114482

275.5927

MAT017

27.8635

109314

9.33

110113

5.29

112800

13.2435

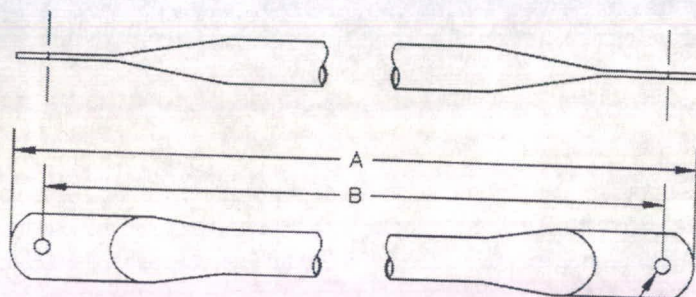
13  
8/10/05/12





**DART**

DESIGN		DRAWN BY		<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED		APPROVED		DRAWING NO. D2565	REV. E SHEET 1 OF 1
DATE 04.05.05				TITLE STRUT	SCALE 1:3
A	96.05.03	NEW ISSUE			
B	97.03.15	CORRECT D2565-111 DIM. A			
C	98.10.05	UPDATED MATERIAL NOTE (TSR A603)			
D	02.06.05	ADD -3XX PARTS; ADD FINISH			
E	04.05.05	ADD D2565-401-411; RMV ANGLE D			

**RELEASED**  
04.05.05 

DIA 0.257 TO BE PUNCHED  
"C" DIA TO BE OPENED MANUALLY  
PUNCH ENDS PER SPEC CONTROL DRAWING D2638

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER

NO. 58294

8810-5-03

PART #	A	B	DIA C
D2565-101	20.52	19.72	0.316
D2565-103	18.21	17.41	0.316
D2565-105	20.19	19.39	0.316
D2565-107	13.43	12.63	-
D2565-109	12.31	11.51	-
D2565-111	13.65	12.85	-
D2565-201	22.79	22.00	0.316
D2565-203	20.75	19.95	0.316
D2565-205	21.22	20.42	0.316
D2565-207	16.07	15.27	-
D2565-209	15.16	14.36	-
D2565-211	14.14	13.34	-
D2565-301	27.03	26.23	0.316
D2565-303	25.34	24.54	0.316
D2565-305	23.73	22.93	0.316
D2565-307	20.86	20.06	-
D2565-309	20.17	19.37	-
D2565-311	16.30	15.50	-
D2565-401	18.29	17.49	0.316
D2565-403	15.64	14.84	0.316
D2565-405	19.45	18.65	0.316
D2565-407	10.79	9.99	-
D2565-409	9.34	8.54	-
D2565-411	13.81	13.01	-

**GENERAL NOTES**

- 1) MATERIAL: AISI 304/316/318 SS 0.750 OD X 0.049 WALL  
(REF DART SPEC. M304TR0.750W0.049)  
ENSURE SEAMLESS TUBE IS USED
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES

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